

5/42

DART AEROSPACE LTD	Work Order:	24477
Description: Bearpaw Installation	Part Number:	D044-662-011
Dwg: D3075 Rev. A2	Qty:	14 20 Kits
Ref: IIN-D044-662 Rev. B; DSK086-12 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																												
1	DC	Issue Traveler Note: (1) D044-662-011 Kit consists of Qty (2) D3075-1 Dwg not required	DA	05.10.12	1.4 20																																												
2	DC	Photocopy bluefile and create labels per PPP D044-662-011 CHG002	DA	05-10-19	20																																												
3	GA	Cut 2 blanks per (1) D044-662-011 Kit Cut blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12 Material: Black UHMW 1" (MUHMWB10) Batch: M15726 M15461	CP	05/10/11	14 kits																																												
4	MV	Inspect material for defects or damage prior to machining	SA	05.10.13	14																																												
5	MV	Machine as per Folio FA185 and Dwg D3075 Identify as D3075-1	SA	05.10.13	14																																												
6	QC2	Inspect parts as they come off the CNC machine	SA	05.10.13	14																																												
7	MV	Deburr	SA	05.10.13	14																																												
8	QC8 & 5	Second inspection	SA	05.10.13	14																																												
9	KP	Pick: Packing Kit (Note: D3075-1 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B045</td><td>Rubber Cushion</td><td>3817095/53 B23172</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>6 B22494/74 B23372/32 B24066</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>20 B22504/92 B23177</td></tr><tr><td>4</td><td>D2882</td><td>Clamp</td><td>B20702 A</td></tr><tr><td>2</td><td>D3075-1</td><td>Bearpaw</td><td>B24477</td></tr><tr><td>4</td><td>AN4-14A</td><td>Bolt</td><td>M15072</td></tr><tr><td>4</td><td>AN4-15A</td><td>Bolt</td><td>16 m16067 / 40 m17566</td></tr><tr><td>8</td><td>AN960JD416</td><td>Washer</td><td>16 m15993 / 192 m17566</td></tr><tr><td>8</td><td>MS21042L4-</td><td>Nut (or -4)</td><td>16 m15924 / 192 m17492</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	4	D2182B045	Rubber Cushion	3817095/53 B23172	8	D2274	Radius Block	6 B22494/74 B23372/32 B24066	8	D2529	Washer	20 B22504/92 B23177	4	D2882	Clamp	B20702 A	2	D3075-1	Bearpaw	B24477	4	AN4-14A	Bolt	M15072	4	AN4-15A	Bolt	16 m16067 / 40 m17566	8	AN960JD416	Washer	16 m15993 / 192 m17566	8	MS21042L4-	Nut (or -4)	16 m15924 / 192 m17492	1	Paperwork package from Step 2			CP	05/10/19	14
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10	QC4	Inspect Kit for 100% Completeness on the W/O	DL	05/10/19	14																																												
11	PK	Identify and pack for shipping as per PPP D044-662-011 RCV = B	DL	05/10/19	14																																												
12	AC	Cost / part 102.18	SA	05.10.20	14																																												
13	DC	Close W/O 100.06 Inspect Level 21	CP	05/10/20	14																																												

Rev	Date	Change	Revised By	Approved
A	02.01.15	New Issue	NG/EC	
B	03.06.02	Reformat; Incorporated D3075-1	KJ/RF	
C	04.02.19	Added tolerance and ref to DSK086-12 to Step 3	KJ/JLM	

RCP 0000576

RELEASED
04.02.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24477
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075	Rev: A2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.072 x 45°	✓			
B	0.63	+/-0.030	0.621	✓			
C	0.250	+/-0.010	0.242	✓			
D	0.950	+0.030/-0.010	0.951	✓			
E	5.50	+/-0.030	5.506	✓			
F	0.25 x 45°	+/-0.030	0.255 x 45°	✓			
G	0.900	+/-0.010	0.897	—			
H	0.375	+/-0.010	0.377	—			
I	1.30	+/-0.030	1.304	—			
J	5.70	+/-0.030	5.701	—			
K	0.37	+/-0.030	0.385	—			
L	3.600	+/-0.010	3.600	✓			
M	0.260	+0.005/-0.000	0.260	—			
N	0.93	+/-0.030	0.929	✓			
O	0.30	+0.030/-0.000	0.300	—			
P	1.08	+/-0.030	1.062	✓			
Q	5.870	+/-0.010	5.877	—			
R	10.14	+/-0.030	10.143	—			

Measured by:	En	Audited by:	ml	Prototype Approval:	N/A
Date:	05/10/11	Date:	05/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	P/O D044-662-011	KJ/RF

RELEASED

RT 04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
07:41 am

Work Order No : 0024477
Project Name : D044-662-011
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : *D044-662-011
Description : R44 Bearpaw Kit
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 10-14-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00